

Work Order ID 63824

Tuesday, November 16, 2010 2:25:50 PM



Page 1

Item ID: D350-636-012

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube RH

Start Date: 11/15/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date: 10/15/16

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN-D350-636

H

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-012 CHG 006

8.12.12/21

JB 63824 10-12-17

363824

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00



Skidtubes

0.00

Skidtubes

Skidtubes

Memo

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.
SECOND SIDE

8- Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail L to 0.500" (8 holes per side)

9- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10- Open up holes of Detail A to 0.297" (total of 2 holes per side)

1 0 BEC/12/07

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QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004

A/R Aluminum Rod batch: M115778 BE 10/12/07

12-Grind welds flush as per Dwg D2750 BE 10/12/07

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

8 10/12/06

Memo

0.00

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8 10/12/06

Memo

0.00

(40)

W/O:		WORK ORDER CHANGES					
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Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

SAD
10-12-08

(1)

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

DP

10-12-8

W/O:		WORK ORDER CHANGES					
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Run Start



QC: Date: SPC (Y/N): Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160



Skidtubes

Skidtubes

0.00

0.00

Memo

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R ☐ Sikaflex-291 batch: M116040 ☐☐☐
exp. date: 11-09-30

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9)

A/R ☐ Aluminum Rod batch: M115778

9- At section AP-AP drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

11-Spot face ground handling holes section (total of 4 places per side) as per

BE 10/12/08

BE 10/12/09

BE 10/12/09

BE 10/12/09

BE 10/12/09

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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dwg D2750

12-Deburr holes

JE 10/2/09

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

S 10/12/13

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S 10/12/13

(2)

W/O:		WORK ORDER CHANGES					
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Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190

Pressure Wash per QSI005 4.3

0.00

=) 10/12/17



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1 10-12-13

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

M115951.

Memo

0.00

Powder Coating

START TIME: 3:50
OVEN TEMPERATURE: 320°
FINISH TIME: 4:20

1 10-12-13

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

=) 10/12/14

1 10-12-13

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	HandFinishing	0.00							
HandFinish	Memo	0.00				1	0		
Hand Finishing	✓ Install inserts as per dwg D2750								
230	HandFinishing	0.00							
HandFinish	Memo	0.00				1	0		
Hand Finishing	✓ 1-Inspect for Foreign Objects 2-Spray inside of tube with "LPS-3" batch: <u>NIA</u> 3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750 ✓ SIKA FLEX 241 BATCH: <u>M115114</u> EXP DATE: <u>11/01</u> 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube ✓ A/R 55-o'ring lube batch: <u>M114189</u> 5-Coat all exposed fasteners with "LPS Procyon" ✓ batch: <u>M114596</u>								

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC5- Inspect part completeness to step on W/O	0.00							
	QC	0.00							
Quality Control	Memo								
250	Pick Kit	0.00							
	Packaging	0.00							
Packaging	Memo								
260	QC4- 100% Inspect kits for completeness	0.00							
	QC	0.00							
Quality Control	Memo								

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

270



Packaging

Packaging

Packaging

Memo

Package as per PPP D350-636-012

0.00

ROOT

0.00

Loc 72

10/12/22

280



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

10/12/22

CL 10/12/22

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

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Parent Item Name: Skidtube RH



Start Date: 11/15/2010

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Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC
 IPP Rev: M 08-04-22 update steps 4,13 DD verified by: EC
 IPP Rev: N 08-09-23 revF as per dwg DD verified by: ec IPP Rev: O
 10.06.22 revise seq110 DD verf: EC IPP Rev: P 10.10.01 as
 per IIN revH DD verf: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

ALS4-1032-225

Purchased

No

220

Each

4,520.000

38

38



Insert



10/12/14

Location

Loc Qty

Loc Code

PK011

4520

110768

4520

x38

AN3C5A

Purchased

No

230

Each

888.0000

34

34



Bolt



10/12/14

Location

Loc Qty

Loc Code

ST350

878

114330

11

115015

13

115371

100

115422

100

115594

282

115835

372

V34

ST351

10

113121

10

Dart Aerospace Ltd

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Start Date: 11/15/2010

Required Date: 11/30/2010



Start Qty: 1.00

Required Qty: 1.00

AN3C6A Purchased No 230 Each 245.0000 4 4

 BOLT  YH 10/12/14

Location Loc Qty Loc Code
 ST351 245

111982 245

AN6C44A Purchased No 230 Each 119.0000 4 4

 BOLT  YH 10/12/14

Location Loc Qty Loc Code
 FG 2

103964 2



ST344 117

111649 2

114653 1

114941 64

115936 50



AN8C35A Purchased No 230 Each 54.0000 1 1

 BOLT  YH 10/12/14

Location Loc Qty Loc Code
 ST346 54

114442 5

115188 22

115960 27

AN960C10L NAS1149C0332 Purchased No 230 Each 25.0000 38 38

 washer  YH 10/12/14

Location Loc Qty Loc Code
 ST245 25

107534 25

1115832

X38

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Shop Packet Print

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Start Date: 11/15/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

AN960C816L

Purchased No

230

Each

0.0000

1

1



NAS1149C08332R / M114915



V1 10/12/14

WASHER

D2745

Manufactured No

230

Each

265.0000

8

8



10/12/14

Bushing

Location

Loc Qty

Loc Code

ST023

265

52311

5

59112

4

61203

44

61988

104

63315

108

V8

D3488-042

Manufactured No

230

Each

24.0000

1

1



10/12/14

Blade Fitting Assembly, RH

Location

Loc Qty

Loc Code

FP008

15

59643

5

62003

10

FP18

9

61690

9

X1

D3492-041

Manufactured No

230

Each

76.0000

8

8



10/12/14

Plug Assembly

Location

Loc Qty

Loc Code

FP013

76

59114

1

61987

14

62210

61

13 63 994

X1

X7

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Start Date: 11/15/2010



Required Date: 11/30/2010

Start Qty: 1.00



Required Qty: 1.00

D3492-043 Manufactured No 230 Each 85.0000 8 8

 Plug Assembly  ML 10/12/14



Location	Loc Qty	Loc Code
FP	2	B63996
54682	2	<u>X2</u>
FP013	83	
59117	1	
59190	4	
62663	78	<u>X6</u>

D3535-25 Manufactured No 230 Each 21.0000 1 1

 Wearshoe  ML 10/12/14

Location	Loc Qty	Loc Code
FP18	21	
62033	7	
<u>62233</u>	14	<u>V1</u>

D3536-25 Manufactured No 230 Each 4.0000 1 1

 Gasket  ML 10/12/14

Location	Loc Qty	Loc Code
FP12	4	B63857
61707	4	<u>V1</u>

D3537-1 Manufactured No 230 Each 18.0000 3 3

 Wearpad  ML 10/12/14

Location	Loc Qty	Loc Code
FP017	18	B63545
62661	9	<u>Y3</u>
63313	9	

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 5

Work Order ID: 63824

Parent Item: D350-636-012


Parent Item Name: Skidtube R

Start Date: 11/15/2010

Required Date: 11/30/2010


Start Qty: 1.00

Required Qty: 1.00

D3631-1 Manufactured No 230 Each 281.0000 8 8

Washer


Location	Loc Qty	Loc Code
ST072	281	
60755	81	
63647	200	

X8

D3672-1 Manufactured No 230 Each 665.0000 4 4

Phenolic Washer


Location	Loc Qty	Loc Code
ST077	665	
42329	10	
52505	655	

X4

D3791-1 Manufactured No 230 Each 19.0000 1 1

Wearplate

Location	Loc Qty	Loc Code
FP17	19	
61702	7	
62239	12	

X1

D3793-1 Manufactured No 230 Each 16.0000 1 1

Wearshoe

Location	Loc Qty	Loc Code
FP18	16	
59151	1	
59630	1	
61244	1	
61710	13	

X1

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 6

Work Order ID: 63824

Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 11/15/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

D3793-3 Manufactured No 230 Each 13.0000 1 1
  HL 10/12/11
 Wearshoe



Location Loc Qty Loc Code

FP18 12

61711 12

FP19 1



57947 1

D3794-1 Manufactured No 230 Each 20.0000 1 1
  HL 10/12/11
 Gasket

Location Loc Qty Loc Code

FP010 20

61704 20

D3794-3 Manufactured No 230 Each 25.0000 1 1
  HL 10/12/11
 Gasket

Location Loc Qty Loc Code



FP10 24

60826 1

61712 23

FP18 1

59153 1

MS21043-6 Purchased No 230 Each 618.0000 4 4
  HL 10/12/11
 NUT

Location Loc Qty Loc Code

ST301 618

112314 618

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 7

Work Order ID: 63824

Parent Item: D350-636-012

Parent Item Name: Skatube RH

Start Date: 11/15/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

230

Each

87.0000

1

1



11/12/11

NUT

Location

Loc Qty

Loc Code

ST303

87

1116289

11

113845

5

114934

3

115594

29

115884

50

NAS1611-010

Purchased

No

230

Each

309.0000

8

8



11/12/11 PTG =>

O-RING

Location

Loc Qty

Loc Code

FP

309

110715

100

110915

159

115589

50

NAS1611-013

Purchased

No

230

Each

228.0000

8

8



11/12/11

O-RING

Location

Loc Qty

Loc Code

FP

228

1116289

115460

100

115589

28

115812

100

11

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Page 7

Dart Aerospace Ltd

W/O: 63824		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/12/14	230	Replace NAS1611-010"O" rings for D2594-3/ M61762 "O" rings	GU	10/12/14	x8		S. W. H.

Part No: D350-636-012 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 8

Work Order ID: 63824

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 11/15/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased No

250 Each

45.0000

2

2



BOLT



10/12/2008

Location

Loc Qty

Loc Code

ST345

45

113558

1

114653

4

115723

40

AN960JD816

Purchased No

250 Each

123.0000

2

2



1/2" washer, Alum



10/12/2008

Location

Loc Qty

Loc Code

ST348

123

106043

123

D2741

Manufactured No

250 Each

25.0000

1



Blade, 350 Skidtube



10/12/2008

Location

Loc Qty

Loc Code

ST466

25

60210

25

D3493-1

Manufactured No

250 Each

36.0000

2

2



Washer



10/12/2008

Location

Loc Qty

Loc Code

ST062

36

61672

36

2

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 63824

Parent Item: D350-636-012

Parent Item Name: Solidtube RH

Start Date: 11/15/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

D3532-1 Manufactured No

250 Each

47.0000

2

2



Spacer

Location

Loc Qty

Loc Code

ST065

47

61673

5

62218

42

D3672-13 Purchased No

250 Each

792.0000

2

2



Phenolic Washer

Location

Loc Qty

Loc Code

ST077

792

54363

792

MS21083C8 Purchased No

250 Each

87.0000

1

2



NUT

Location

Loc Qty

Loc Code

ST303

87

113845

5

114934

3

115594

29

115884

50

D2600-3-BENT Manufactured No

110 Each

13.0000

1

1



Extrusion Bent

Location

Loc Qty

Loc Code

LG

13

61634

4

62594

8

62764

1

10/12/2010

2

NAS 10/12/21
Remire !!

10/12/2010

2

BE 10/12/07

B 64434 (1)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 63824



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 11/15/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

D2744

Manufactured No

110

Each

39.0000

1

1



Cap

Location

Loc Qty

Loc Code

LG

6

59198

6

ST

33

62715

33

1 BE10/12/07

D2739

Manufactured No

160

Each

12.0000

1

1



350 I Beam

Location

Loc Qty

Loc Code

LG

12

62563

8

62688

4

1 BE10/12/08

D2743

Manufactured No

160

Each

150.0000

8

8



Crossbolt Spacer

Location

Loc Qty

Loc Code

LG

150

50281

10

57953

2

59111

31

61844

107

8 BE10/12/09

D3490-3

Manufactured No

160

Each

39.0000

4

4



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

39

60294

1

62668

38

4 BE10/12/09

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 63824



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 11/15/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

D3490-1

Manufactured

No

160

Each

95.0000

4

4



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

95

59424

3

61217

2

62450

90

4 BE 10/12/09

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

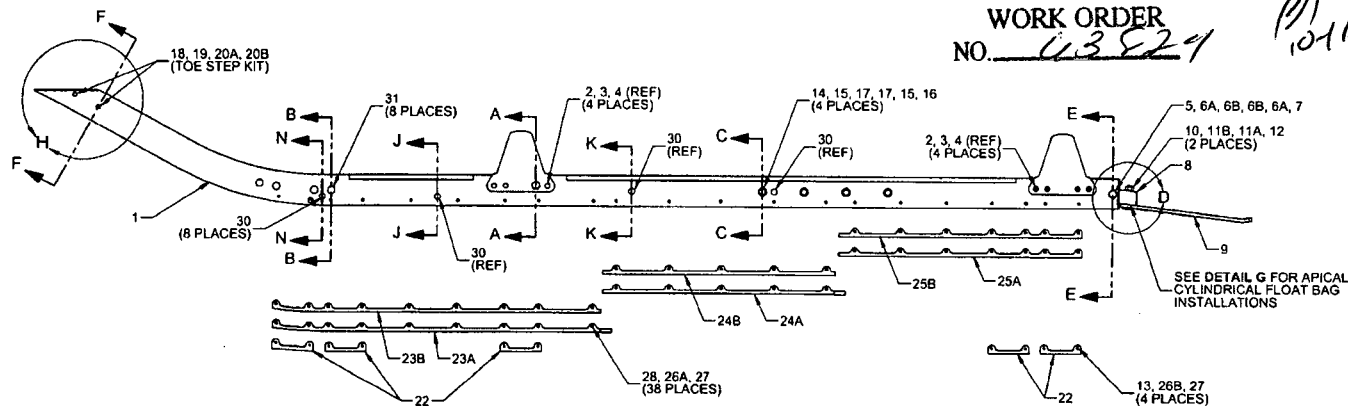
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

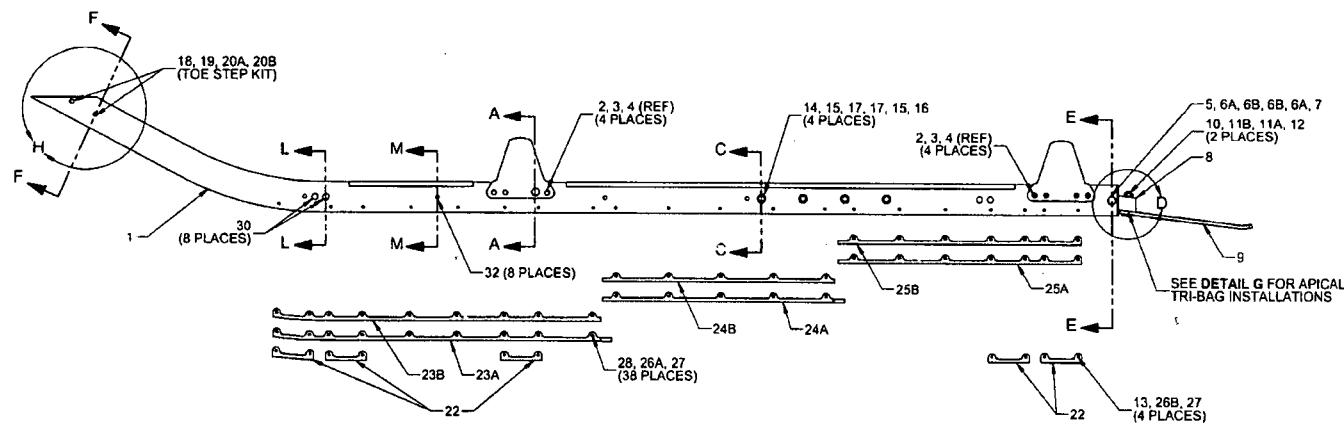
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D350-636-011/-012 ASSEMBLY
(Aerazur / Apical Cylindrical)



D350-636-013/-014 ASSEMBLY
(Aircruiser / Apical Tri-Bag)

Figure 1: D350-636-011/-012-013-014 SKIDTUBE ASSEMBLY AT CHG 003

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Revision: **H**

Date: 10.07.26

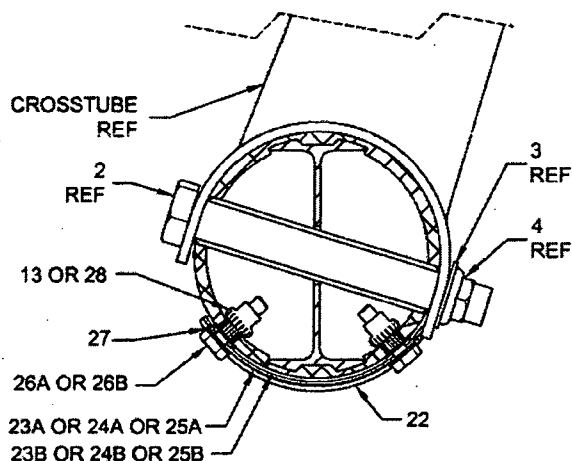
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

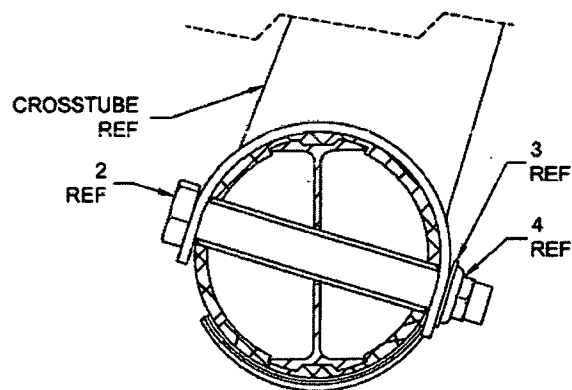
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

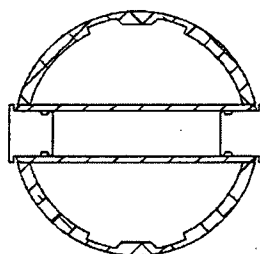
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SECTION A-A
(D350-636-011/-012/-013/-014 SKIDTUBES
AT CHG 003 ONLY)

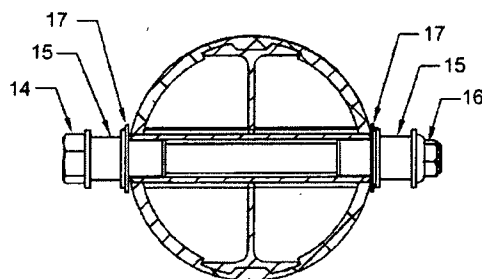


SECTION P-P
(D350-636-011/-012/-013/-014 SKIDTUBES
AT CHG 004 OR SUBSEQUENT)



SECTION B-B
(SECTION J-J, K-K, L-L AND M-M SIMILAR)
8 PL PER SKIDTUBE

w/o 63824



SECTION C-C
4 PL PER SKIDTUBE

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Date: 10.07.26

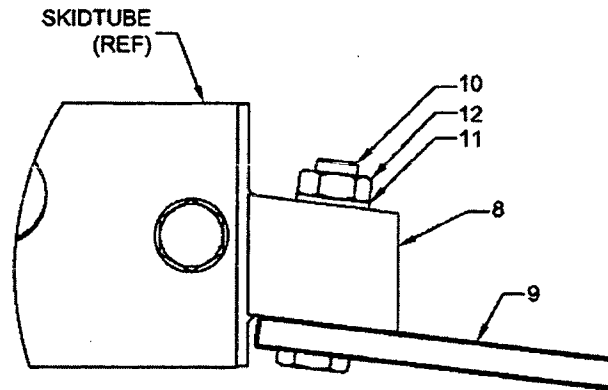
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

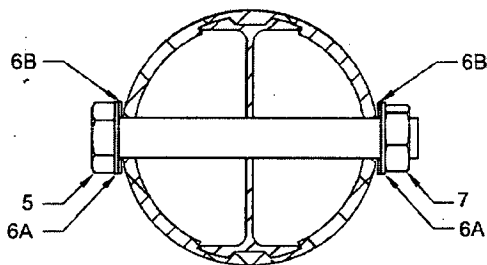
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

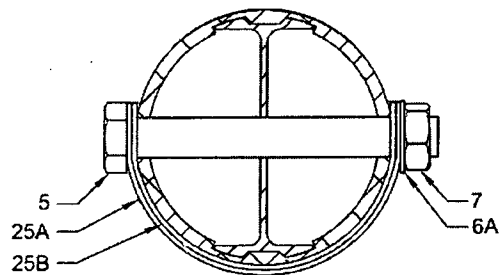
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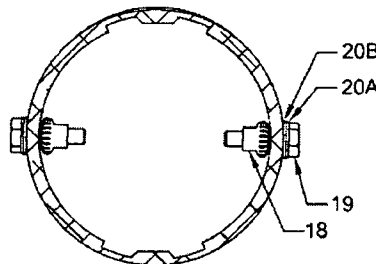
DETAIL D
1 PL PER SKIDTUBE



SECTION E-E
(D350-636-011/-012/-013/-014 SKIDTUBES
AT CHG 003 ONLY)



SECTION Q-Q
(D350-636-011/-012/-013/-014 SKIDTUBES
AT CHG 004 OR SUBSEQUENT)



SECTION F-F
2 PL PER SKIDTUBE

w/ 43824

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

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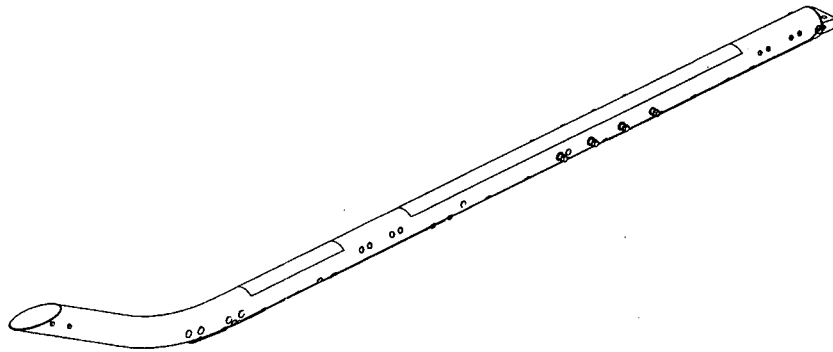
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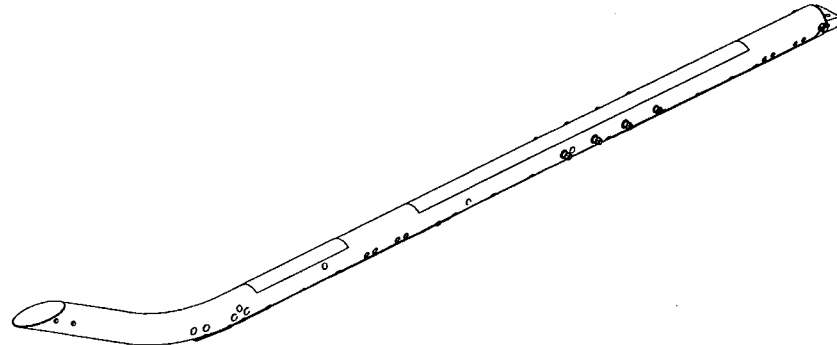
- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL *F*
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS, ADD D3631-1; REMOVE QTY (38) NAS1515H3L, REMOVE QTY (10) NAS1515H8L, REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEC 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4, INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>	DART AEROSPACE USA, INC.	
DRAWN	<i>PH</i>	PORT HADLOCK, WA	
CHECKED	<i>AP</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>AP</i>	D2750	SHEET 1 OF 11
APPROVED	<i>AP</i>	TITLE	SCALE
DE APPR.	<i>AP</i>	350 SKIDTUBE ASSEMBLY	NTS
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W1663824



D2750-041 350 SKIDTUBE ASSEMBLY, LH

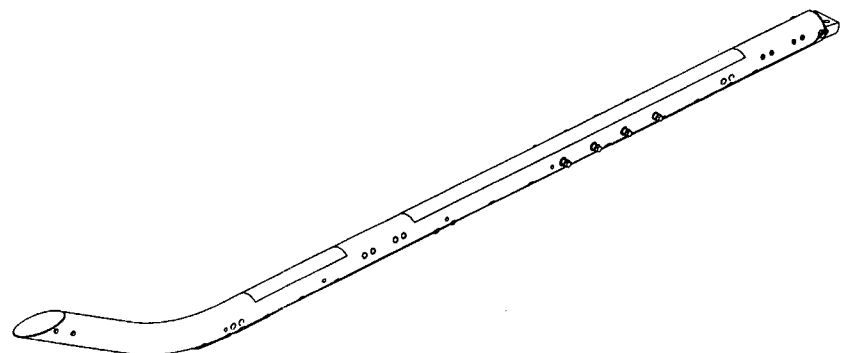


D2750-042 350 SKIDTUBE ASSEMBLY, RH

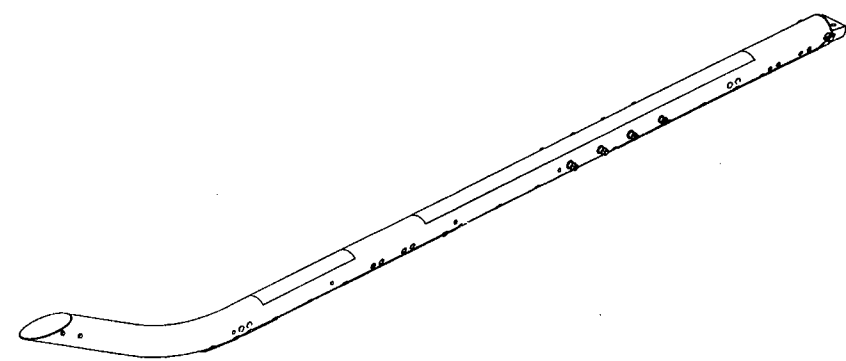
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08.07.16

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED	PCY	DRAWING NO.	REV. F
MFG. APPR.	NA	D2750	SHEET 2 OF 11
APPROVED	NA	TITLE	SCALE
DE APPR.	NA	350 SKIDTUBE ASSEMBLY	NTS
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w/63824



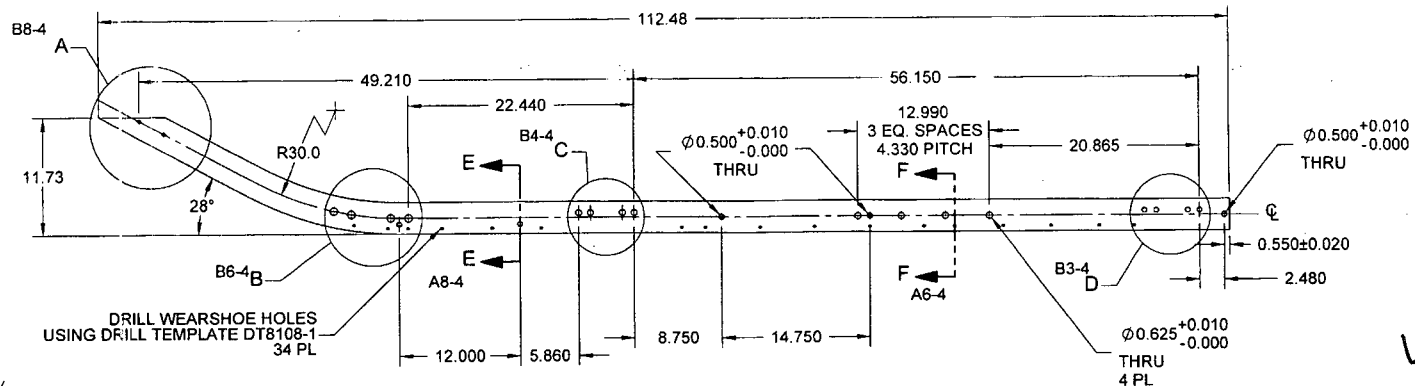
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D2750-044 350 SKIDTUBE ASSEMBLY, RH

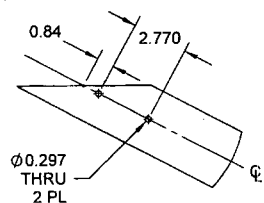
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DESIGN	PD	DART AEROSPACE USA, INC.	
DRAWN	PD	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 3 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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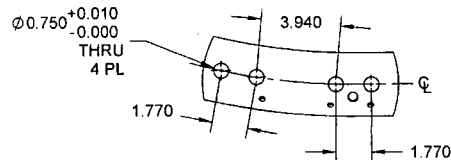


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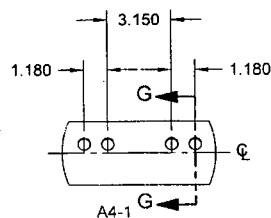
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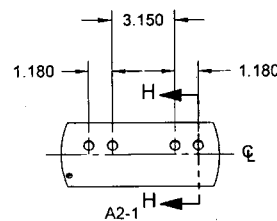
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SCALE 2X



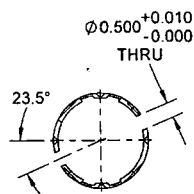
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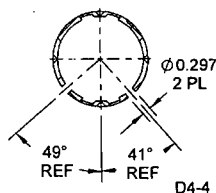
DETAIL C
SCALE 2X



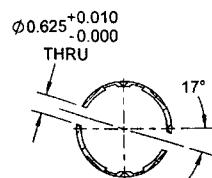
DETAIL D
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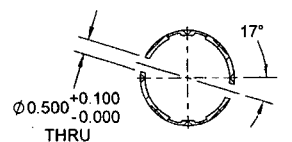
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



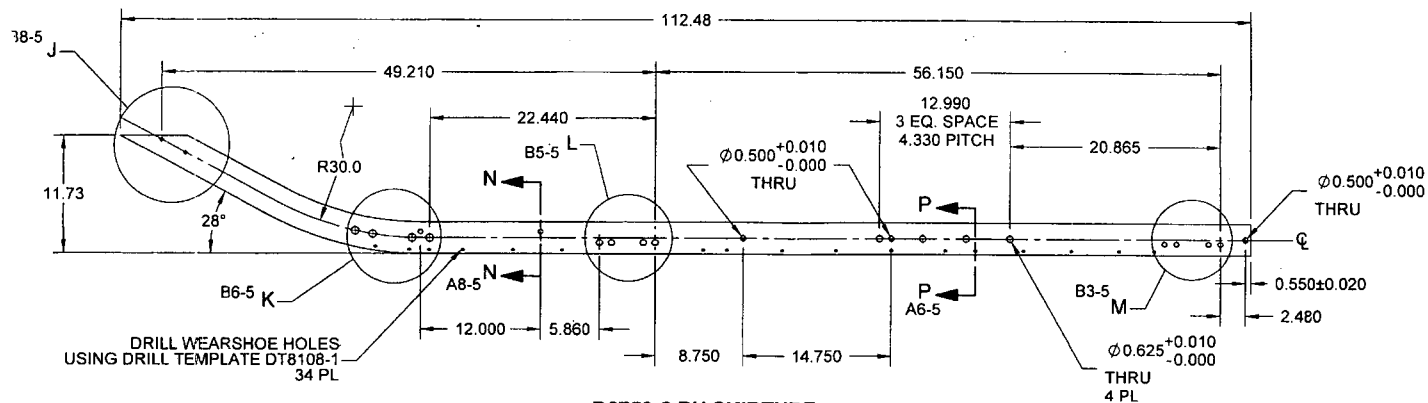
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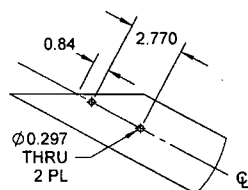
SECTION H-H
SCALE 3X, 4 PL

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CHECKED	1/1	DRAWING NO.	REV. F
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APPROVED	1/1	TITLE	SCALE
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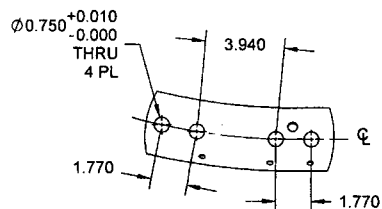
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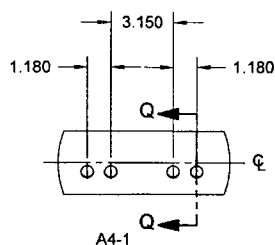
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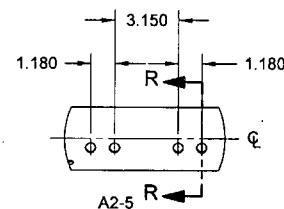
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SCALE 2X



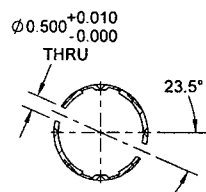
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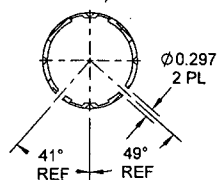
DETAIL L
SCALE 2X



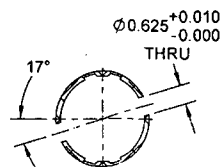
DETAIL M
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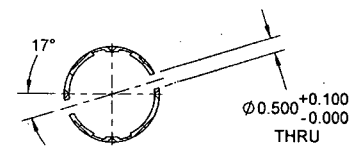
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

DESIGN	REV	DART AEROSPACE USA, INC.	
DRAWN	REV	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 5 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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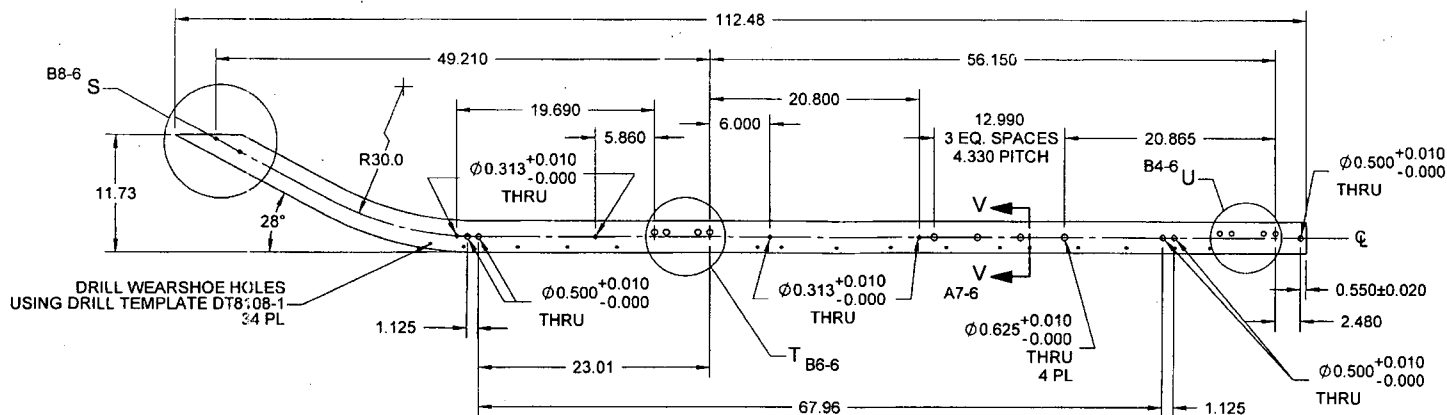
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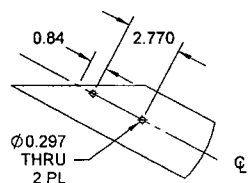
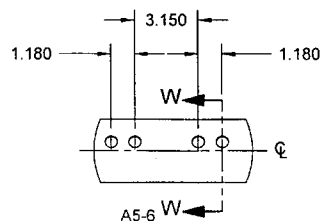
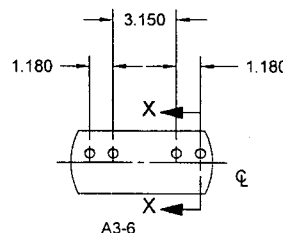
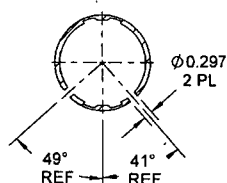
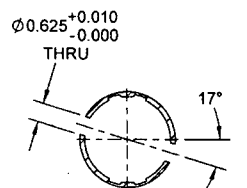
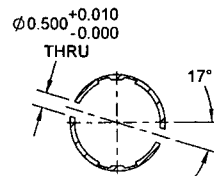
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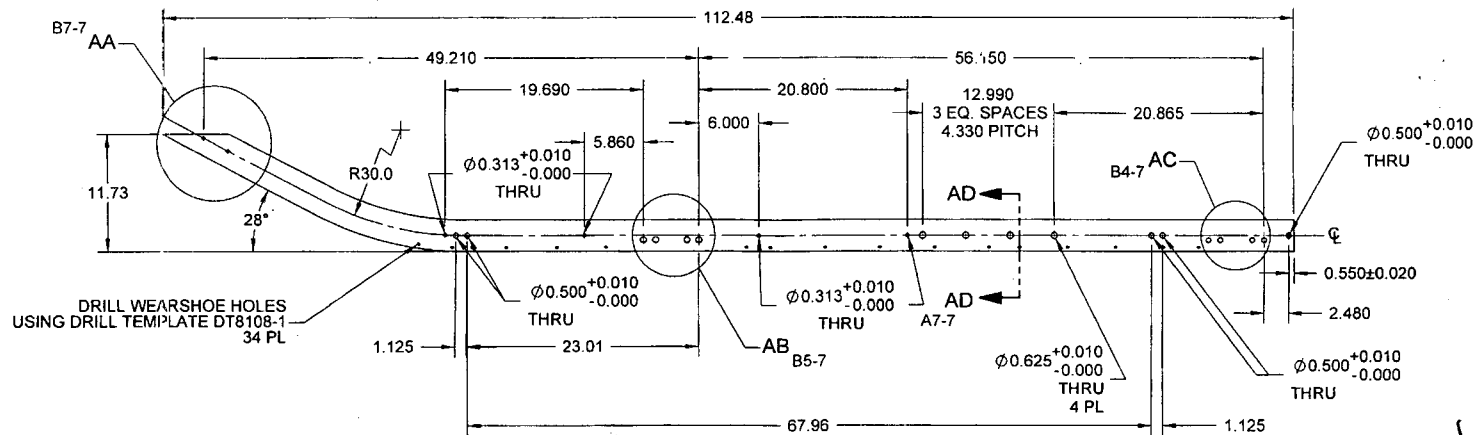
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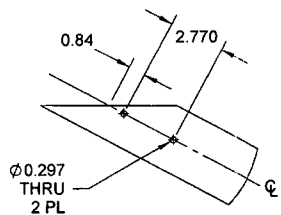
D2750-3 LH SKIDTUBE

DETAIL S
SCALE 2XDETAIL T
SCALE 2XDETAIL U
SCALE 2XSECTION V-V
SCALE 3X, 17 PLSECTION W-W
SCALE 3X, 4 PLSECTION X-X
SCALE 3X, 4 PLRELEASED
08.07.16

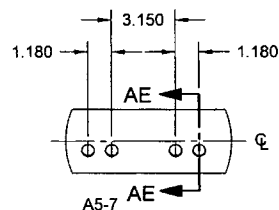
DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 6 OF 11
APPROVED		TITLE	SCALE
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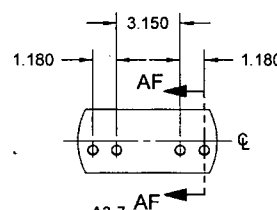
D2750-4 RH SKIDTUBE



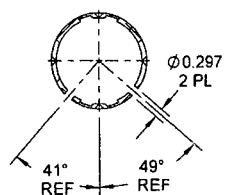
DETAIL AA
SCALE 2X



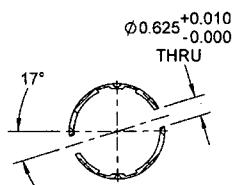
DETAIL AB
SCALE 2X



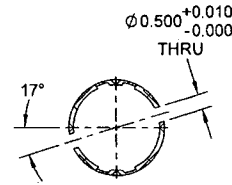
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



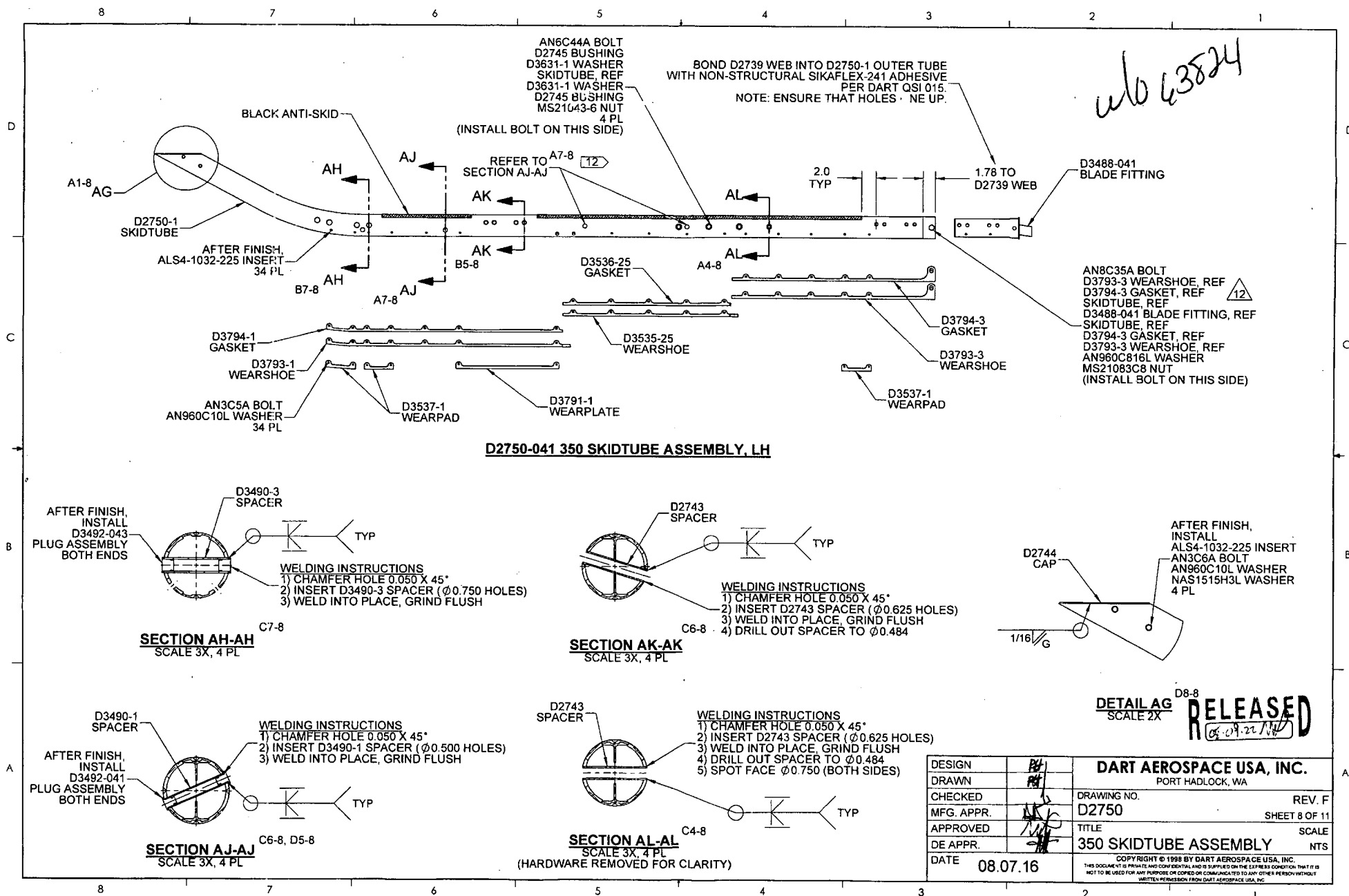
SECTION AE-AE
SCALE 3X, 4 PL



SECTION AF-AF
SCALE 3X, 4 PL

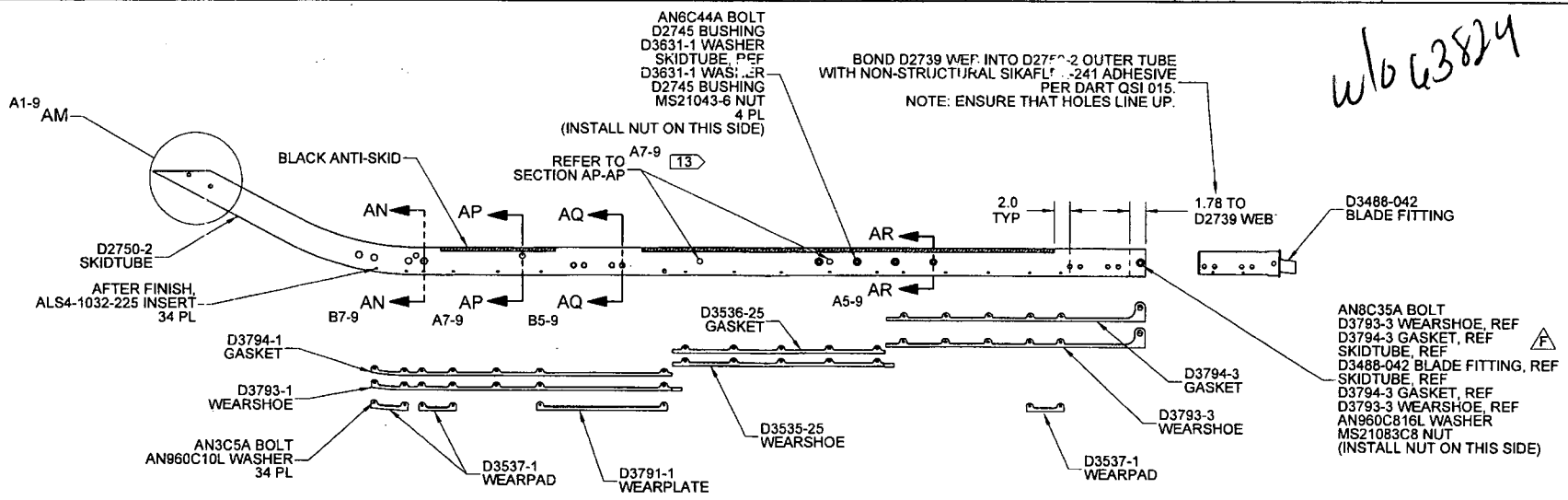
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DRAWN	REV. F	PORT HADLOCK, WA	
CHECKED	REV. F	DRAWING NO.	REV. F
MFG. APPR.	REV. F	D2750	SHEET 7 OF 11
APPROVED	REV. F	TITLE	SCALE
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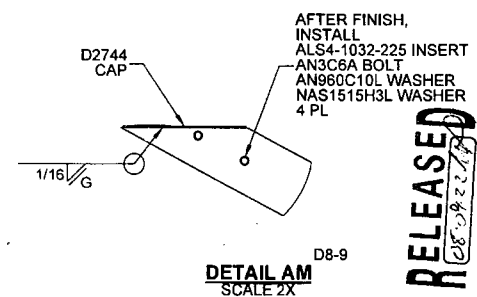
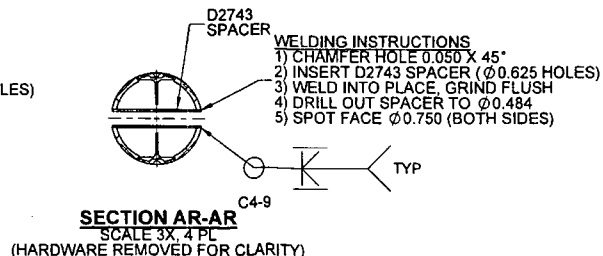
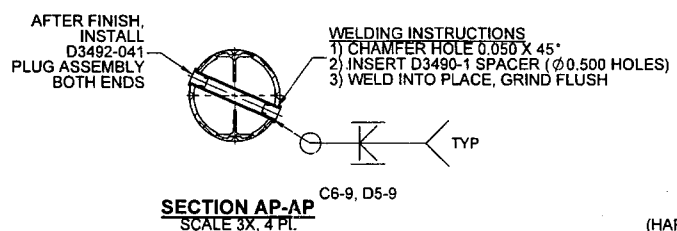
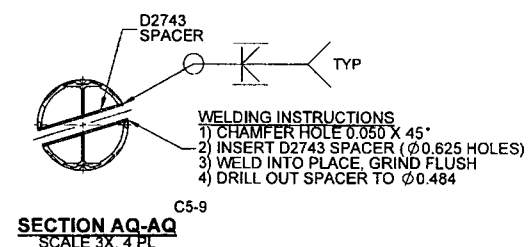
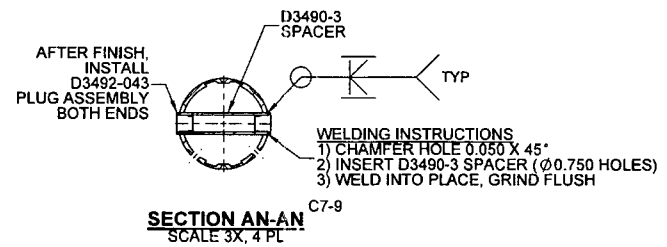


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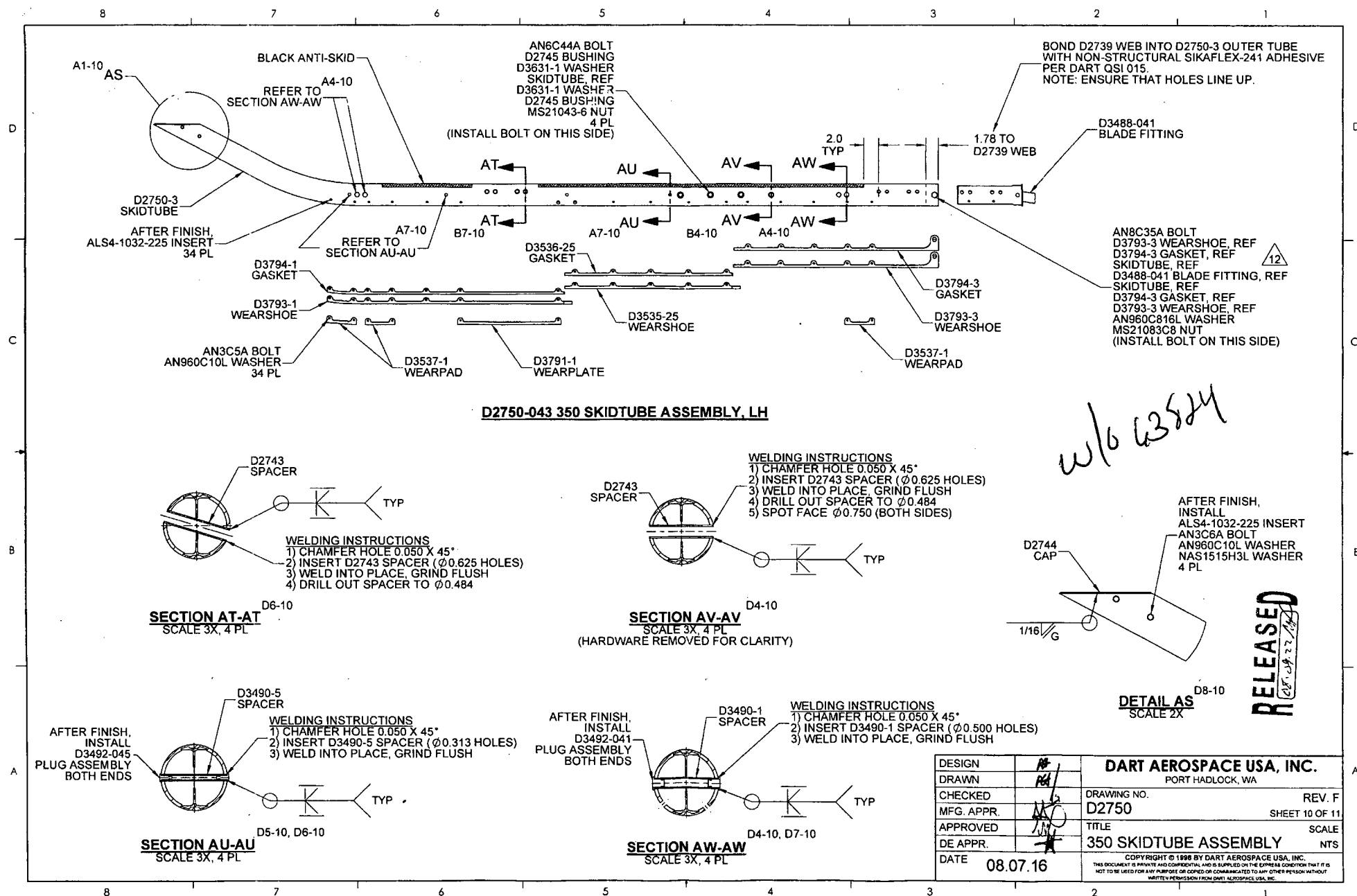


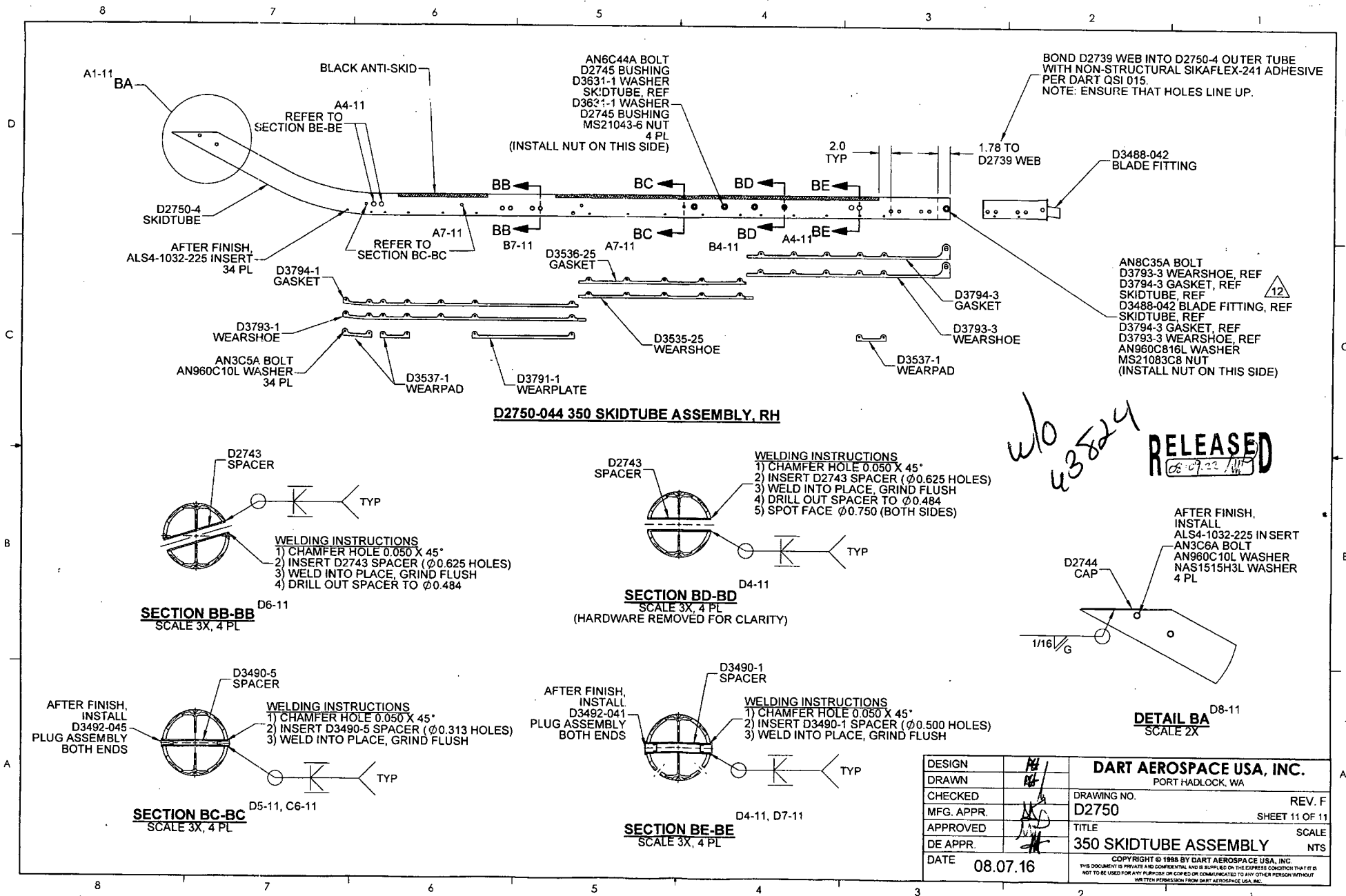
D2750-042 350 SKIDTUBE ASSEMBLY, RH



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08-09-2017

DESIGN	PA	DART AEROSPACE USA, INC.	
DRAWN	BL	PORT HADLOCK, WA	
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MFG. APPR.		D2750	SHEET 9 OF 11
APPROVED		TITLE	SCALE
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NO. 239

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barday Elliott
Job number: 6194 61914
Part number: D350.636.012
Description: 350 skid
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier P. J. D. Date of Test Coupon 10.09.30
Welder Barday Elliott Date of Test Coupon 10.09.30

The above named individual is qualified in accordance with AWS D17.1.2001 to weld